

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003557**Date Inspected:** 04-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Robert Vatcher arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following: The weather today is 27C, clear with winds south east & increased at 6-7 kph.

OBG Bay 7

Orthotropic Box Girder (OBG) Fabrication

QA was assigned/ tasked as part of 3rd shift operations with routinely Witness Inspection Notification reports from ZPMC QC personnel. Multiple welds had been documented as being Magnetic Particle examined (MT) by ZPMC non destructive testing (NDT) personnel in OBG Bay 7. QA performed follow up (MT) on the following piece marks for contractor compliance.

FB010-007 welds 002, 010, 013, 014, 021, 022, 027, 030, 034, 038, 041, 042, 044, 047, 048 & 061

FB015-009 welds 002, 010, 013, 014, 021, 022, 027, 030, 033, 037, 047, 048 & 061

FB012-004 welds 002, 010, 013, 014, 021, 022, 027, 030, 004, 037, 038, 041, 042, 047, 048 & 061

FB010-008 welds 002, 010, 013, 014, 021, 022, 027, 030, 034, 038, 041, 042, 044, 047, 048 & 061

FB002-005 welds 002, 010, 013, 014, 021, 022, 027, 030, 034, 038, 041, 042, 044, 047, 048 & 061

FB040-001 welds 147 & 135

FB003-026 welds 002 & 023

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FB003-021 welds 002 & 023

FB003-034 welds 002 & 023

QA observed that although it was tasked to perform MT on FB028-002 & FB040-001 it appeared that said components were overturned making access difficult or unachievable.

The above mentioned items, as tested by QA appear to be in compliance with the contract documents.

Summary of Conversations:

No relevant conversations this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 138-1694-2685, who represents the Office of Structural Materials for your project.

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| Inspected By: | Vatcher,Robert |
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| Quality Assurance Inspector |
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| Reviewed By: | Cuellar,Robert |
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| QA Reviewer |
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